

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020032**Date Inspected:** 19-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder( OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12BW, PP114.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC Personnel performing Ultrasonic Testing (UT) of Floor beam to longitudinal diaphragm weld Identified as SEG3005E-021. The attached photographs provide additional detail.

Assembly, Bay 14, 11DE, X35 Stiffener.

SMAW welding of weld joint SEG072D-061, 064; located on assembly, Bay 14, 11DE. Welder is identified as 215553; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: 1)WPS-B-P-2213-TC-U4B-FCM.

Assembly, Bay 14, 12CE, FL2-1.

FCAW welding of weld joint FB3030-001-011, 016; located on assembly, Bay 14, 12CE. Welder is identified as 058551; ZPMC Quality Control Inspector (QC) is identified as Geng wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4B-F.

Assembly, Bay 14, 12AW, Corner Assembly, Side plate to Edge plate.

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FCAW welding of weld joint CA3007-003; located on assembly, Bay 14, 12AW. Welder is identified as 045175; ZPMC Quality Control Inspector (QC) is identified as Xu Tao. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4B-F.

This QA Inspector carried out NDE on following

Bay 16, Tower Facade.

This QA inspector performs Random Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel (Notification # 005551). This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

- 1)ND1-A264-1, 18, 6, 7.
- 2)ND1-A239-1.
- 3)ND1-A214-3-1, 2, 3.
- 4)ND1-A216-5-3, 4, 5.
- 5)SD1-A263-1, 18, 6, 7.
- 6)SD1-A238-1.
- 7)ND1-A214-5-6, 7, 8.
- 8)ND1-A216-6-5, 6, 7.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Juvekar,Amit

Quality Assurance Inspector

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**Reviewed By:** Miller,Mark

QA Reviewer